

Date: Thursday, 16/10/2008 10:45:13 AM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: BASKET LID ASSEMBLY		
Job Number	: 42630A			Part Number	: D2989041		
Estimate Number	: 10206			Drawing Number	: D2989 REV C		
P.O. Number	:			Project Number	: N/A		
This Issue	: 16/10/2008 S.O. No. :			Drawing Revision	: C		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : LARGE FAB ASSY			Due Date	: 11/11/2008 Qty: 1 Um: Each		
Previous Run	: 42628A						
Written By	:						
Checked & Approved By	: <u>JUL 08 10.16</u>						
Comment	: Est Rev:I Removed D2989-043 05-11-03 JLM Est Rev:J 08-08-29 revC as per dwg DD verified by:EC Est Rev:K 08-09-24 plug hole prior to powder coating DD verified by:EC						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D31663	Basket Hoop	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
		Pick: <input checked="" type="checkbox"/> Qty.(1) D3166-3 Batch: <u>B42717</u>	<u>16/08/11/08</u>
2.0	D2581	Mounting Bracket	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick: <input checked="" type="checkbox"/> Qty Part number Description Batch 2 D2581 Mounting Brackets <u>B40895</u>	<u>16/08/11/08</u>
3.0	D23273	Spacer Bushing	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick: <input checked="" type="checkbox"/> Qty Part number Description Batch 2 D2327-3 Bushing <u>B39560</u>	<u>16/08/11/08</u>
4.0	D2506	Label Plate	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
		Pick: <input checked="" type="checkbox"/> Qty Part number Description Batch 1 D2506 Label Plate <u>B39457</u>	<u>16/08/11/17</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: BASKET LID ASSEMBLY

Job Number: 42630A

Part Number: D2989041

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 M304EX07516F Expanded Metal Flat SS



Comment: Qty.: 15.0000 sf(s)/Unit Total : 15.0000 sf(s)

Pick:

✓ Qty Part number Description Batch  
15sf M304EX0.75-16F Expanded Metal M109383

08/11/17

6.0 M304TS0750W065 304 SQ Tube .75x.75x.065W



Comment: Qty.: 31.7709 f(s)/Unit Total : 31.7709 f(s)

✓ 3/4" x 3/4" x 0.065" wall 304/316 SStubing.

Batch: M109731

08/11/06

7.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut (4) D2236-1 From D3166-3 As Per Dwg D2989

2-Drill holes in tubing as D2989-041 per Dwg D2989

3-Deburr and remove all markings on material

4-Weld as per Dwg D2989 and D2989-041 Assembly using Welding Table and corner Jig. Deburr as required

Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid

5-Drill Ø0.257" hole as D2989-041 per Dwg D2989 Identify as D2989-041

08/11/17

8.0 QC9

VISUAL WELDING INSPECTION



08/11/18

Comment: VISUAL WELDING INSPECTION

9.0 QC5

INSPECT WORK TO CURRENT STEP



S 08/11/18 (S)

Comment: INSPECT WORK TO CURRENT STEP

10.0 POWDER COATING

POWDER COATING



IX

M109152

Comment: POWDER COATING

1- Plug holes in D2581 prior to powder coating

2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

M 08/11/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: BASKET LID ASSEMBLY

Job Number: 42630A

Part Number: D2989041

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Wing walk D2989-041 as per Dwg D2989 and QSI 005 4.4

Spray Paint Black: m109195.

Wing Walk: m109917

- FX 08/11/19 (1X)

1ST COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

\*\*\*\*\* 2nd coat if necessary \*\*\*\*\*

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8 :45  
0F  
400  
9 :15

10 :00  
0F  
400  
10 :30

MR 08/11/19

11.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

S 08/11/20 (2)

12.0 QC21

FINAL INSPECTION/W/O RELEASE



08/11/24 (4)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MR 08/11/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D

D

C

C

B

B

A

A

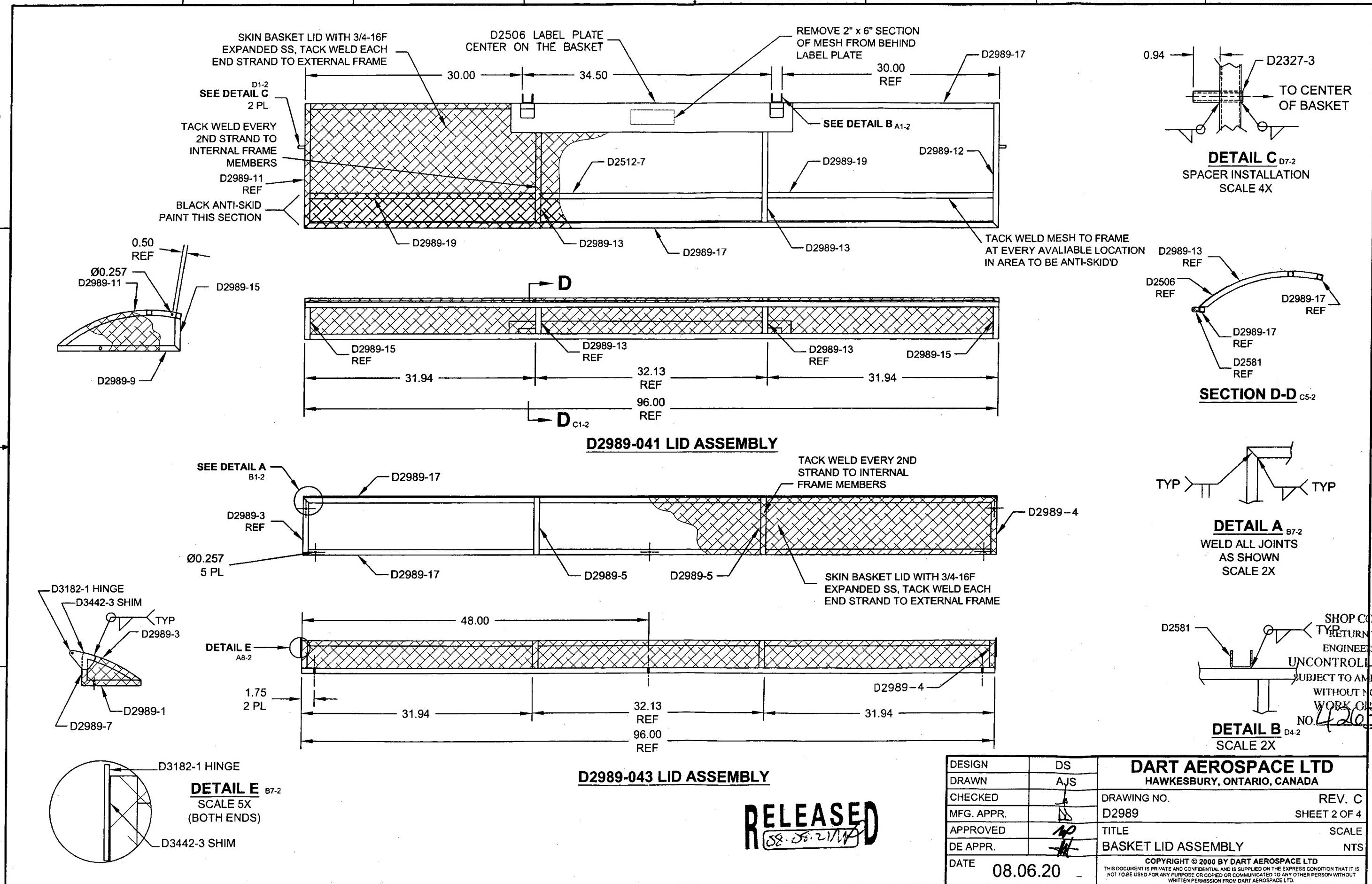
QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X		D2989-041	BASKET LID ASSEMBLY
X		D2989-043	BASKET LID ASSEMBLY
1		D2989-1	STRUT
1		D2989-2	STRUT
1		D2989-3	STRUT
1		D2989-4	STRUT
2		D2989-5	STRUT
2		D2989-7	STRUT
1		D2989-9	STRUT
1		D2989-10	STRUT
1		D2989-11	STRUT
1		D2989-12	STRUT
2		D2989-13	STRUT
2		D2989-15	STRUT
2	2	D2989-17	STRUT
2		D2989-19	STRUT
2		D2327-3	SPACER BUSHING
1		D2506	LABEL PLATE
1		D2512-7	STRUT
2		D2581	MOUNTING BRACKET
		2 D3182-1	HINGE
		2 D3442-3	SHIM

**NOTES:**

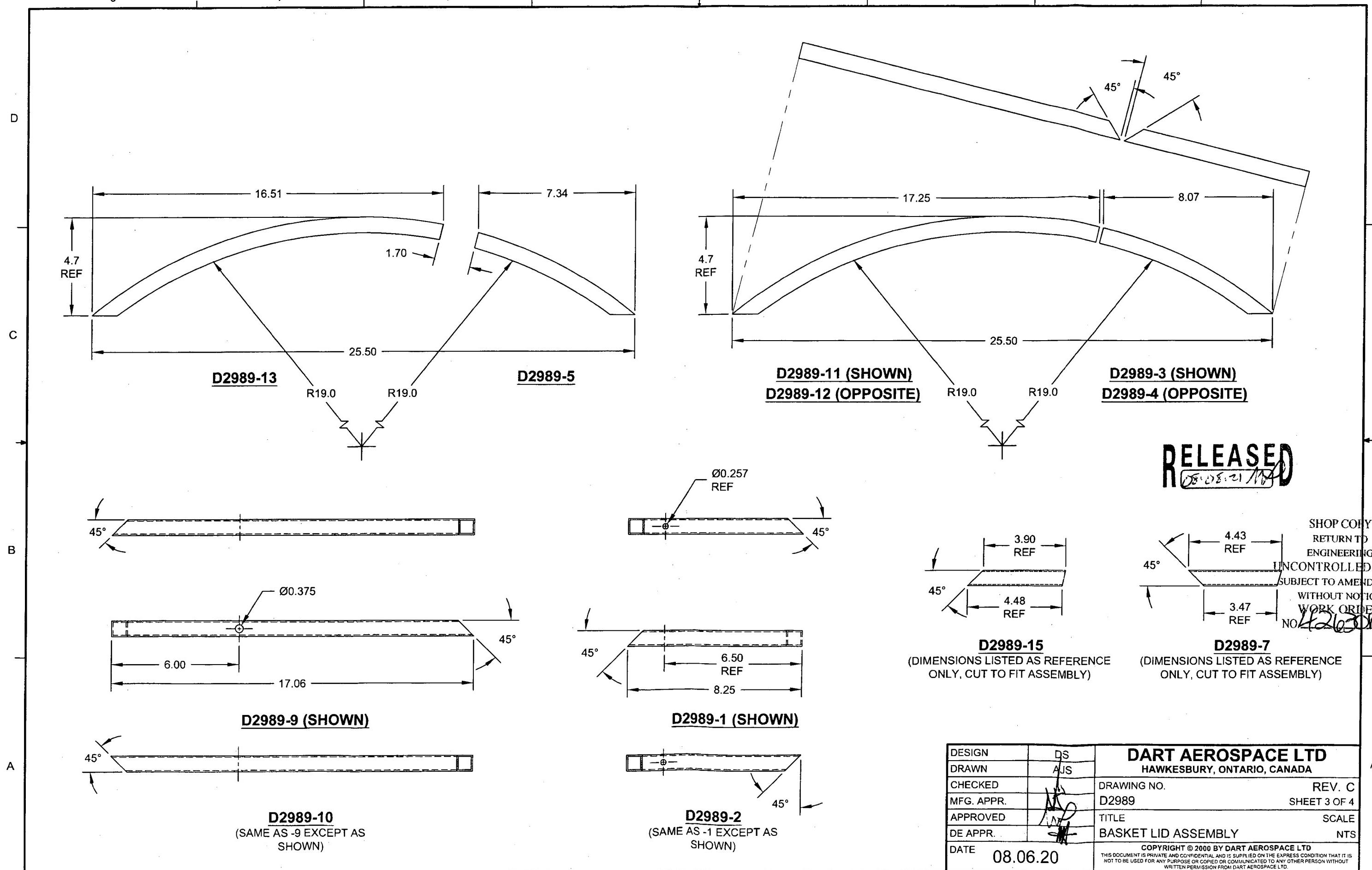
- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING  
REF. DART SPEC M304TS0.750W.065  
(D2989-3/4/5/11/12/13 CAN BE MADE FROM D2236)
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS  
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4.  
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004

C	FRAME MATERIAL WAS 0.060 WALL. MESH MATERIAL UPDATED. DRAWING TRANSFERRED TO "B" SIZE FORMAT & CURRENT DRAFTING STANDARD.	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION		
DESIGN	DS		
DRAWN	AJS		
CHECKED			
MFG. APPR.	DRAWING NO. D2989		
APPROVED	REV. C		
DE APPR.	SHEET 1 OF 4		
DATE	TITLE SCALE		
	BASKET LID ASSEMBLY NTS		
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08.06.2004  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO 42604



8 7 6 5 4 3 2 1

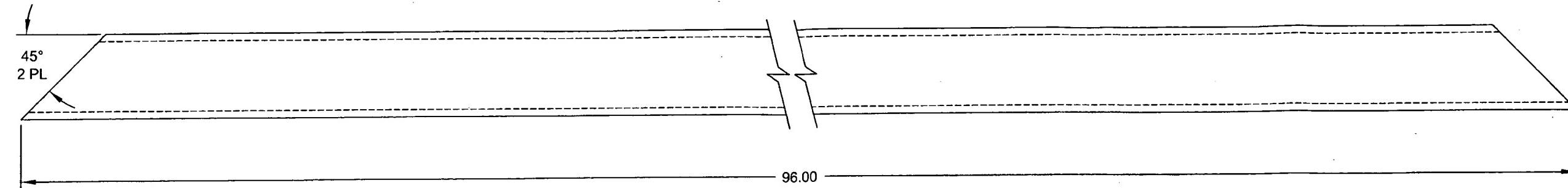


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CHECKED	MJ	DRAWING NO.	
MFG. APPR.	AP	REV. C	
APPROVED	AP	D2989	
DE APPR.	AP	SHEET 3 OF 4	
DATE	08.06.20	TITLE	
		SCALE	
		BASKET LID ASSEMBLY	
		NTS	
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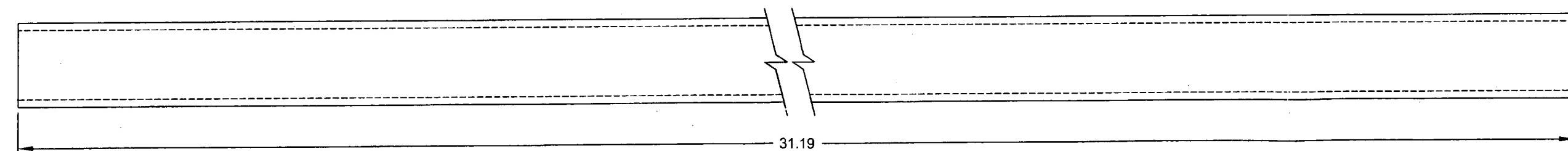
D



**D2989-17 STRUT**

C

C



**D2989-19 STRUT**

B

B

SHOP COPY  
RETURN TO <sup>B</sup>  
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WORK ORDER  
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**RELEASED**  
*08-08-21/11/19*

A

A

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APPROVED	<i>AS</i>	D2989			
DE APPR.	<i>AS</i>	TITLE			
DATE	08.06.20	SCALE			
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